

Split

Work Order ID 135452 -1

Wednesday, August 12, 2015 4:29:10 PM

646.3301
B135452
REV. N/C3

135452

Page 1

Item ID: 646.3301

Revision ID:

Item Name: Upper Cutter Assy

Start Date: 8/12/15

Start Qty: 3.00

Required Date: 8/12/15

Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: AUG 14 2015

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

646.3300

NC3

110

Pick Kit

0.00

110

Packaging

Memo

0.01

Packaging

3x

15/08/24

DAS
36
9-89

120

0.00

120

Small Fab

Memo

0.05

Small Fab

TWO fastener must be install finger-tight (see note 9)

3x

15/08/23

DAS
36
8-89

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.

A/R RTV LOCTITE 598:

M131311

exp. date:

11/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 135452

Wednesday, August 12, 2015 4:29:10 PM

135452

Page 2

Item ID: 646.3301 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Cutter Assy
 Start Date: 8/12/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130						(3)			SEP 24 2015
QC	Memo	0.01							
Quality Control									
140	Identify as per dwg & Stock Location: <u>CCK018</u>	0.00							
140						3	DAS 6 9-89		SEP 24 2015
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP 120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									SEP 24 2015
QC	Memo	0.00							
Quality Control									

20150924
 SH

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
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								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 135452

135452

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP
REV:B 15.01.07 AS PER DWG NC3 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3310 *646.3310* LH Half		Manufactured	No			110	Each	17.0000	1	5		15/08/24	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				MF				17					
				120486				1					
				121853				3					
				124425				10					
				125832				3					
646.3311 *646.3311* RH Half		Manufactured	No			110	Each	11.0000	1	5		15/08/24	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				MF3				11					
				125166				7					
				131608				4					
646.3312 *646.3312* Center Plate		Manufactured	No			110	Each	18.0000	1	5		15/08/24	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				MF				18					
				121871				4					
				125437				9					
				125852				5					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Picklist Print

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Work Order ID: 135452

135452

Parent Item: 646.3301

646 3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 5.00

Required Qty: 5.00

646.3313 Manufactured No

110 Each 6.0000 1 5

646 3313

Upper Guide

**

15/08/24 DAS 36 9-89

Location

Loc Qty

Loc Code

cck102

6

131609

6

646.3314 Manufactured No

110 Each 11.0000 1 5

646 3314

Blade

**

15/08/24 DAS 36 9-89

Location

Loc Qty

Loc Code

MF

11

127669

11

646.3315 Manufactured No

110 Each 7.0000 1 5

646 3315

Blade

**

15/08/24 DAS 36 9-89

Location

Loc Qty

Loc Code

MF

7

123095

4

131610

3

646.3316 Manufactured No

110 Each 2.0000 1 5

646 3316

Blade

**

15/08/24 DAS 36 9-89

Location

Loc Qty

Loc Code

MF

2

127462

2

B135 465 ③ 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use as is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Picklist Print

Wednesday, August 12, 2015 4:29:10 PM

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Work Order ID: 135452

135452

Parent Item: 646.3301

646 3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 5.00

Required Qty: 5.00

NAS1149FN832P

Purchased

No

110

Each

2,963.000

36

180

NAS1149FN832P

Washer

15/08/24 DAS 36 9.89

Location

Loc Qty

Loc Code

ST260a

1704

125268

1704

180

st268

1259

125268

338

M130388

921

MS21042L08

Purchased

No

110

Each

1,162.000

18

90

MS21042L 08

Nut

15/08/24 DAS 36 9.89

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

243

m131697

243

ST304

818

123900

16

m128401

102

m128429

3

m131317

197

m132930

500

90

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. : _____ NCR No. : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
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Past Expiry Date ☐	Manufacturing Process ☐				
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Picklist Print

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Page 4

Work Order ID: 135452

135452

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 5.00

Required Qty: 5.00

NAS1149F0332P

Purchased

No

110

Each

1,516.000

6

30

NAS1149F0332P

Washer

15/08/24
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

222

122063

222

ST260a

1201

m128401

6

m131026

80

m131697

1115

st268

93

123900

7

m130388

86

30

AN3-12A

Purchased

No

110

Each

55.0000

2

10

AN3-12A

Bolt

15/08/24
DAS
36
9-89

Location

Loc Qty

Loc Code

CA

55

m129682

55

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Work Order ID: 135452

135452

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

110

Each

1,578.000

3

15

MS21042L3

Nut

15/08/14 DAS
36
9-89

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

270

M131317

270

ST305

915

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

333

M132930

500

15

MS27039-08-19

Purchased

No

110

Each

670.0000

18

90

MS27039-08-19

Screw

15/08/14 DAS
36
9-89

Location

Loc Qty

Loc Code

ST273A

638

m131317

388

m132930

250

ST281

32

m127904

3

m131264

29

90

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

Wednesday, August 12, 2015 4:29:10 PM

Page 6

Work Order ID: 135452

135452

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 5.00

Required Qty: 5.00

AN3-14A

Purchased

No

110

Each

148.0000

1

5

AN3-14A

Bolt

DAS
36
9-89

15/08/21

Location

Loc Qty

Loc Code

ST338a

100

m132825

100

ST348

48

m132680

48

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

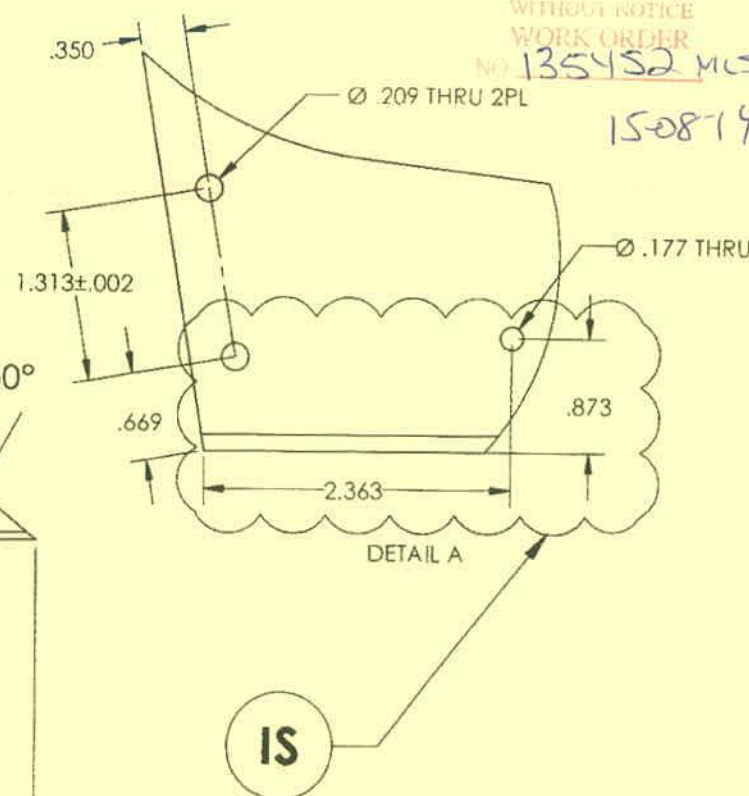
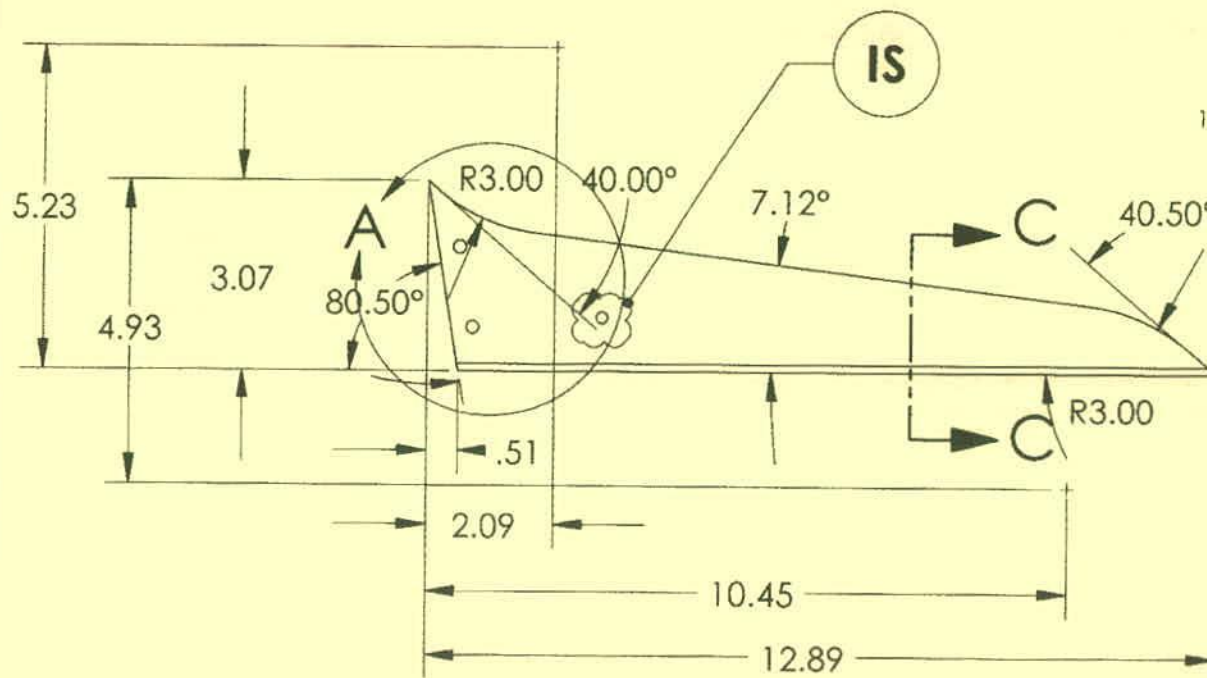
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.		04765		SHEET 1 OF 1	
DWG NO.	646.3300	REV:	NC	PREPARED BY	J. SOTO
DATE:		12/08/2014		EFFECT ON DWG ☐ INC. ☒ UNINC.	
DWG TITLE: UPPER CUTTER ASSY					
APPROVED BY:	ENGR. <i>[Signature]</i>	MFG. <i>[Signature]</i>	QC <i>[Signature]</i>	EFF. NEXT ORDER	
REASON: ADDED HOLE DIMENSION TO 646.3313.					

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

SHEET 5 IS:



SHOW COPY
ATTN: SA TO
INSURANCE
UPON CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 135452 MLS
15-08-14

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03724

SHEET 1 OF 1

DWG NO. 646.3300

REV: N/C

PREPARED
BY B. PETERS

DATE: 12/05/12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC *[Signature]*

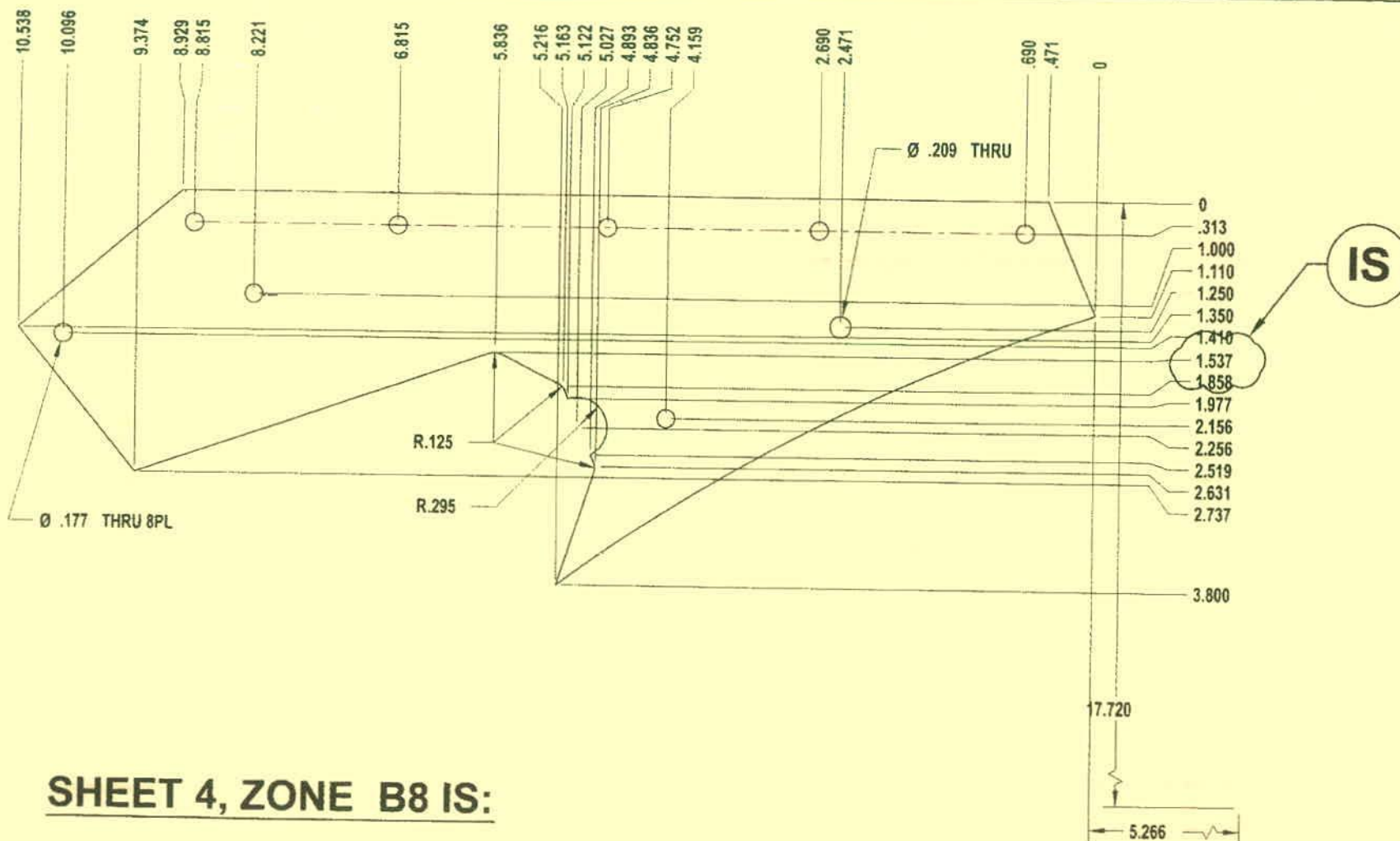
EFF: NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON:

REVISED ORDINATE DIMENSION.

ECR:
D-12-025



SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

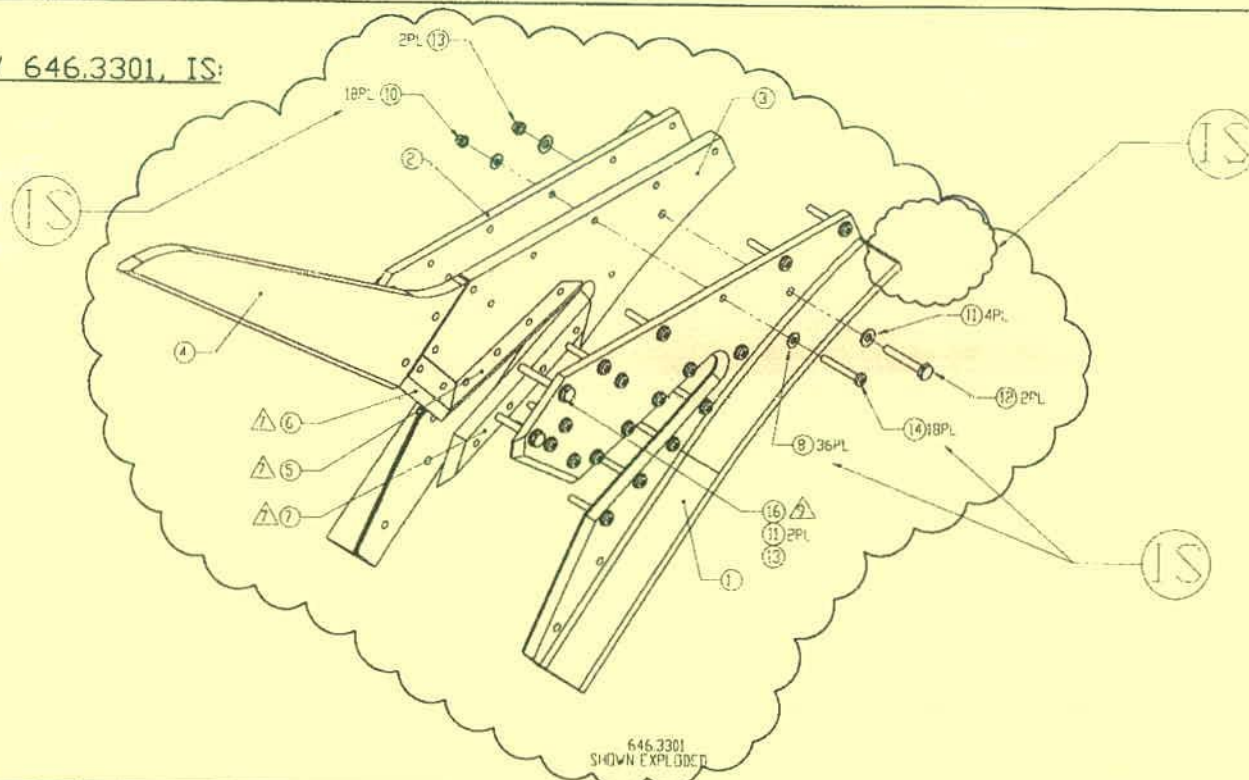
CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

APIICAL
INDUSTRIES, INC.

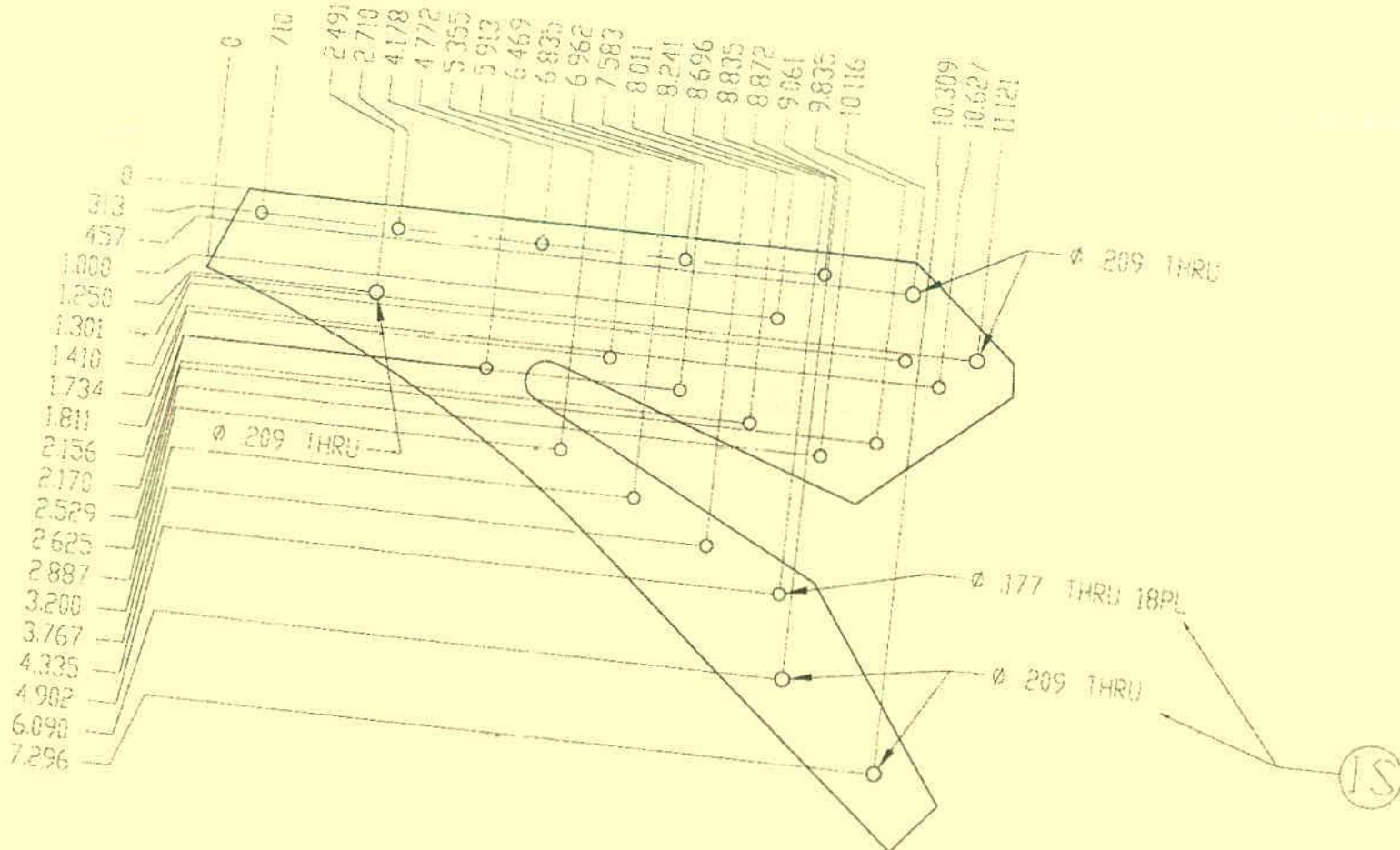
ENGINEERING CHANGE NOTICE NO.		02196		SHEET 1 OF 2	
DWG NO.	646.3300	REV: N/C	PREPARED BY	S. HUFF	DATE: 01/05/09
DWG TITLE:		UPPER CUTTER ASSY			
APPROVED BY:	ENGR <i>[Signature]</i>	MFG	<i>[Signature]</i>	QC	588
					EFF: NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

SHEET 1, VIEW 646.3301, IS:



14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			.3301		
F/N TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION	
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM				☐ MAJOR ☒ MINOR	☐ YES ☒ NO

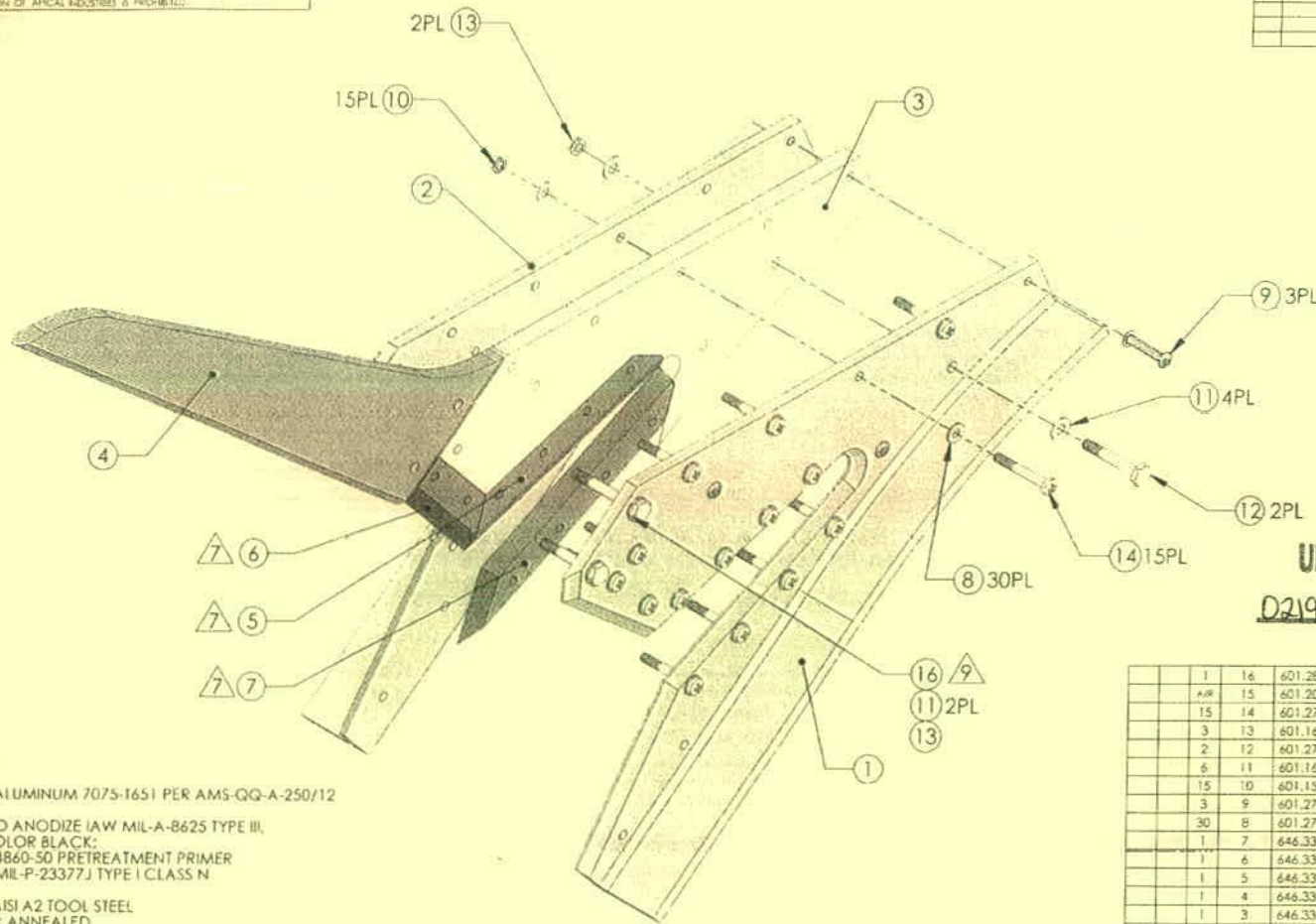
SHEET 3, SECTION VIEW A-A, IS:



SECTION A-A

C PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
---------------	-----	-------------	------------------------

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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT-TREAT TO 58-62 RC ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

UNINCORPORATED ECN(s)

D2196, 03724, 04765

QTY	REV	DESCRIPTION	DATE	APPROVED
1	16	601.2834	BOLT	
15	15	601.2045	RTV, LOCITE 598	
15	14	601.2765	SCREW	
3	13	601.1624	LOCKNUT	
2	12	601.2763	BOLT	
6	11	601.1607	WASHER	
15	10	601.1541	LOCKNUT	
3	9	601.2766	RIVET	
30	8	601.2764	WASHER	
1	7	646.3316	BLADE	
1	6	646.3315	BLADE	
1	5	646.3314	BLADE	
1	4	646.3313	UPPER GUIDE	
1	3	646.3312	CENTER PLATE	
1	2	646.3311	PH HALF	
1	1	646.3310	LH HALF	
1		646.3301	UPPER CUTTER ASSY	
QTY	REV	DESCRIPTION	MATL	SPEC
1	16	601.2834	BOLT	
15	15	601.2045	RTV, LOCITE 598	
15	14	601.2765	SCREW	
3	13	601.1624	LOCKNUT	
2	12	601.2763	BOLT	
6	11	601.1607	WASHER	
15	10	601.1541	LOCKNUT	
3	9	601.2766	RIVET	
30	8	601.2764	WASHER	
1	7	646.3316	BLADE	
1	6	646.3315	BLADE	
1	5	646.3314	BLADE	
1	4	646.3313	UPPER GUIDE	
1	3	646.3312	CENTER PLATE	
1	2	646.3311	PH HALF	
1	1	646.3310	LH HALF	
1		646.3301	UPPER CUTTER ASSY	

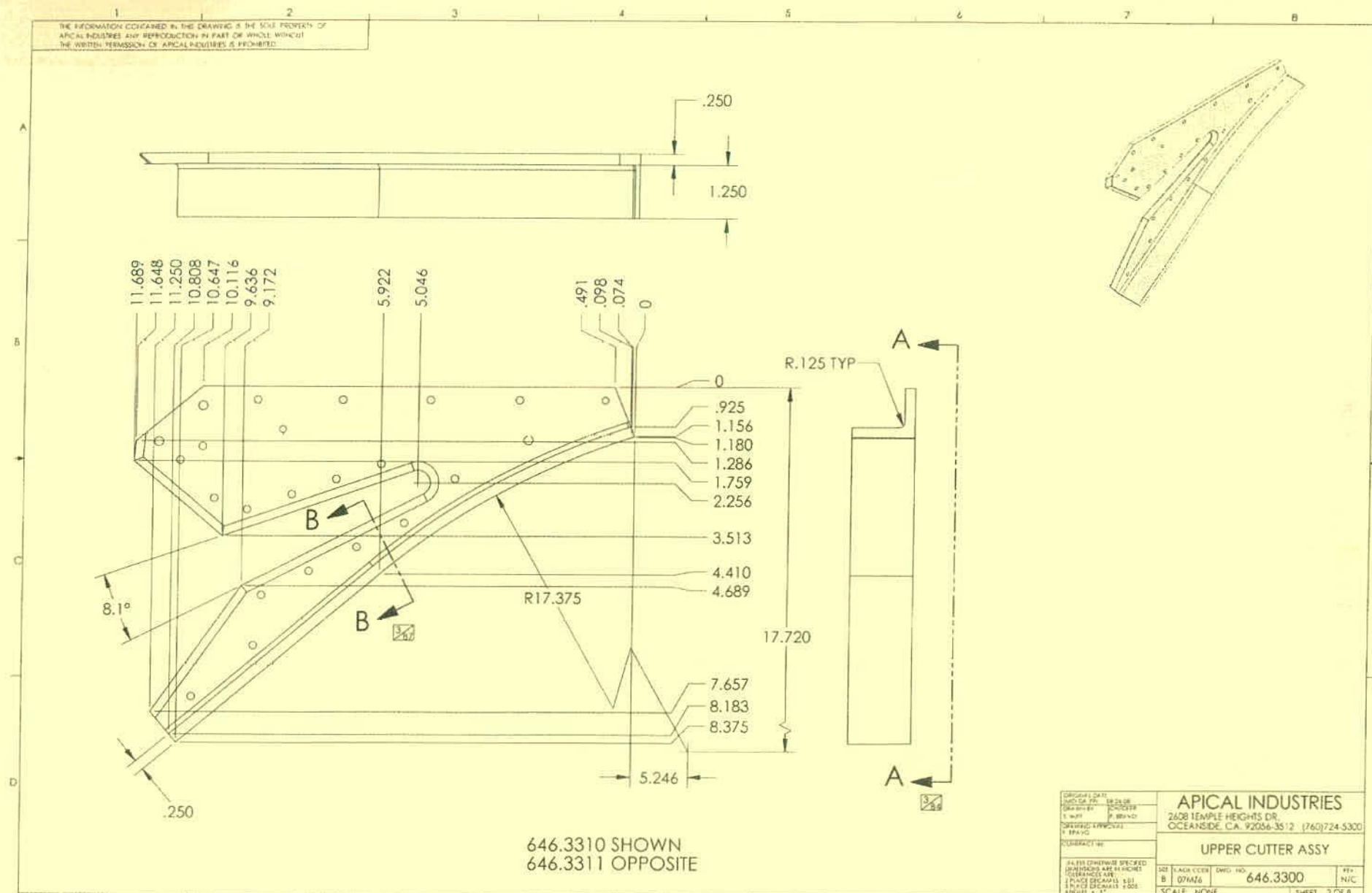
APICAL INDUSTRIES

2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

UPPER CUTTER ASSY

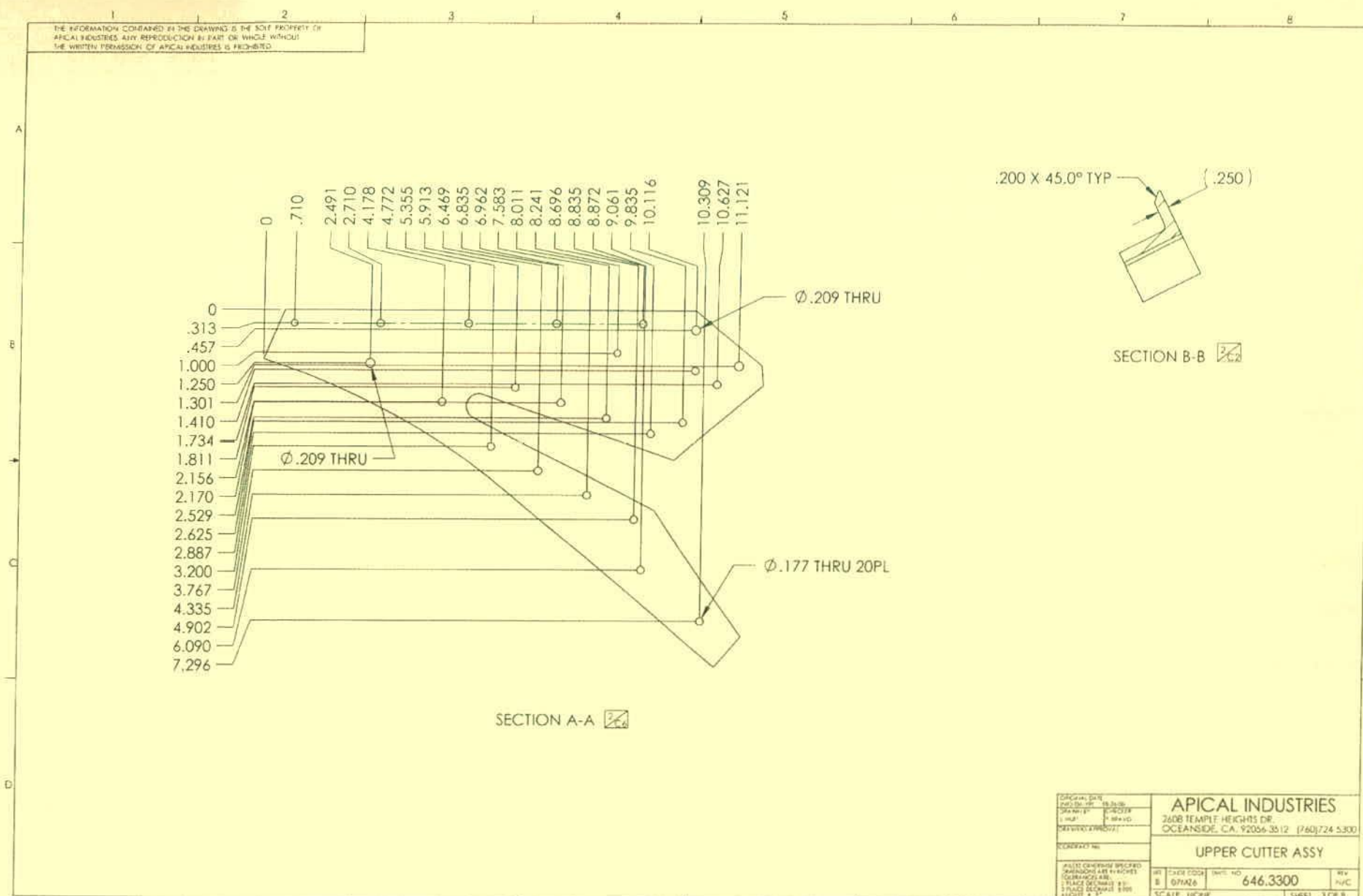
SET CHG CODE DWG. NO. 646.3300
B 07M26
SCALE NONE SHEET 1 OF 8

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ORIGINAL DATE 1/10/04 DESIGNED BY T. WAT DRAWN BY P. BRADY CHECKED BY P. BRADY		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESCRIPTION UPPER CUTTER ASSY		646.3300	
ALL DIMENSIONS SPECIFIED UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES 1:16		SIZE B 07M26	REV N/C
SCALE: NONE		SHEET 2 OF 8	

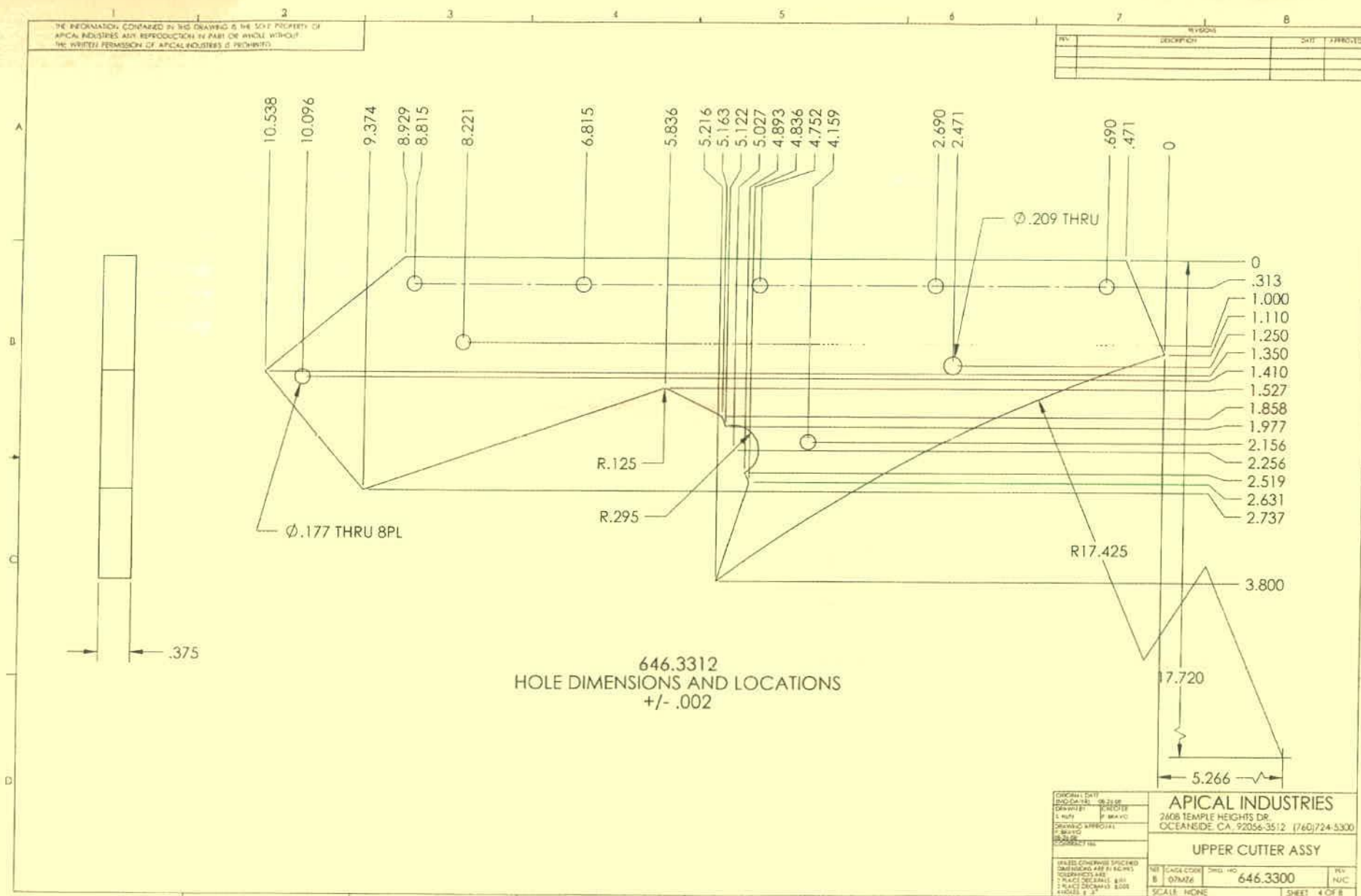
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ORIGINAL DATE 10/10/88 DRAWN BY J. M. J. CHECKED BY J. M. J.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
PROJECT NO. 646.3300		UPPER CUTTER ASSY	
ALL DIMENSIONS SPECIFIED UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.010 2 PLACES DECIMALS ±.005 3 PLACES DECIMALS ±.002		REV. NO. 07/12/86 646.3300 SCALE: 1:1	REV. JVC SHEET 3 OF 8

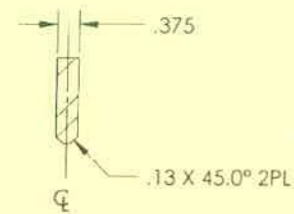
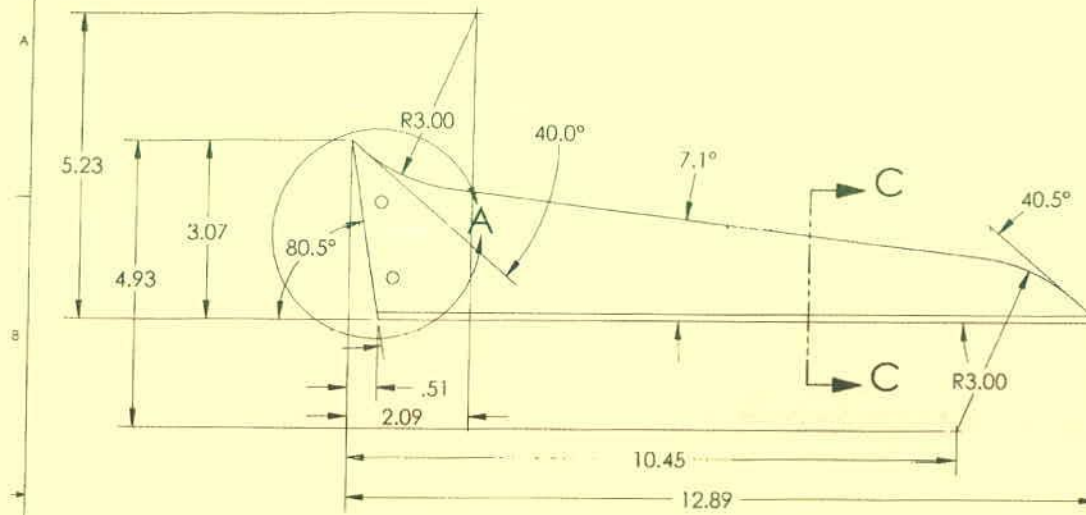
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REV	DESCRIPTION	DATE	APPROVED

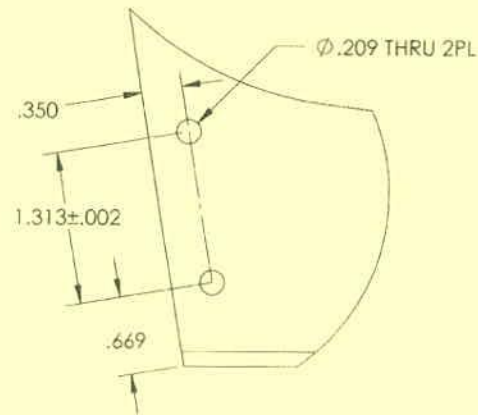


THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

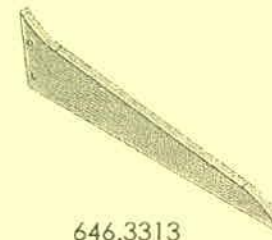
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



DETAIL A

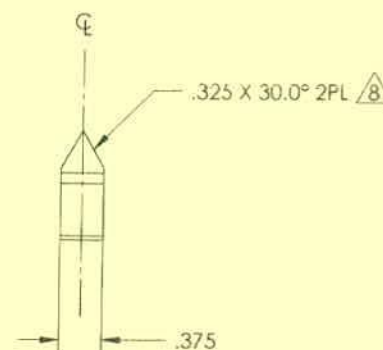
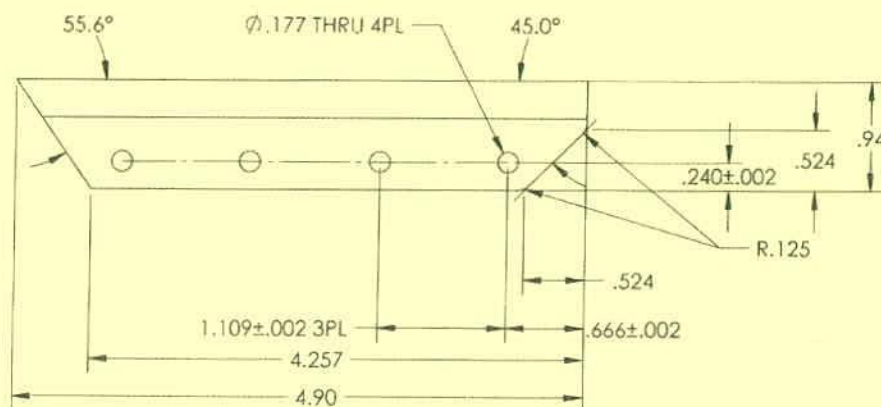


646.3313

ORIGINAL DATE AND DATE OR BY 1. NAME (DESIGNED APPROVAL) P. RAHO (DESIGNED CONTRACTOR)				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300			
(UNLESS OTHERWISE SPECIFIED) DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACES DECIMALS: .010 2. PLACES DECIMALS: .001 3. ANGLES: .1°				UPPER CUTTER ASSY			
SR B	CAGE CODE 07M25	DWG. NO. 646.3300	REV. N/C	SCALE: NONE			
SHEET 5 OF 8				SHEET 5 OF 8			

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

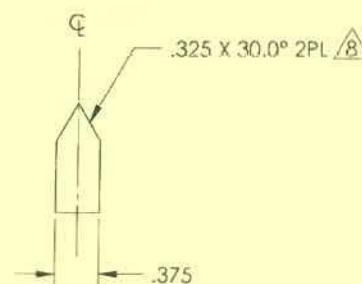
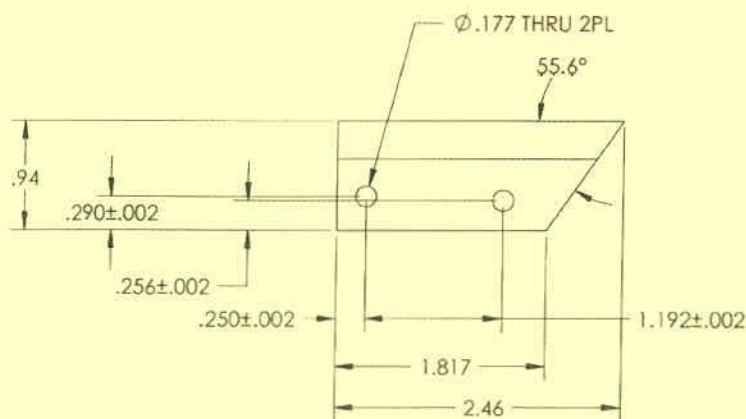
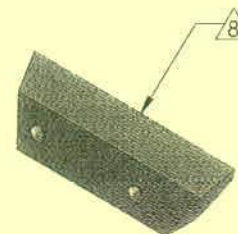


646.3314

ORIGINAL DATE: 10/10/94 DRAWN BY: J. M. B. / DESIGNED BY: J. M. B. CHECKED BY: J. M. B. / APPROVED BY: J. M. B. PART NO: 646.3314		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
UPPER CUTTER ASSY		REV: N/C	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: FRACTIONS DECIMALS ANGLES 1° 3'		NO. 104610001 (SPEC. NO.)	REV: N/C
SCALE: NONE		646.3300	SHEET 6 OF 8

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REVISION			
REV.	DESCRIPTION	DATE	APPROVED

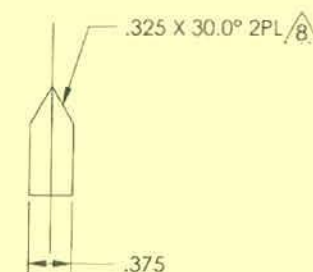
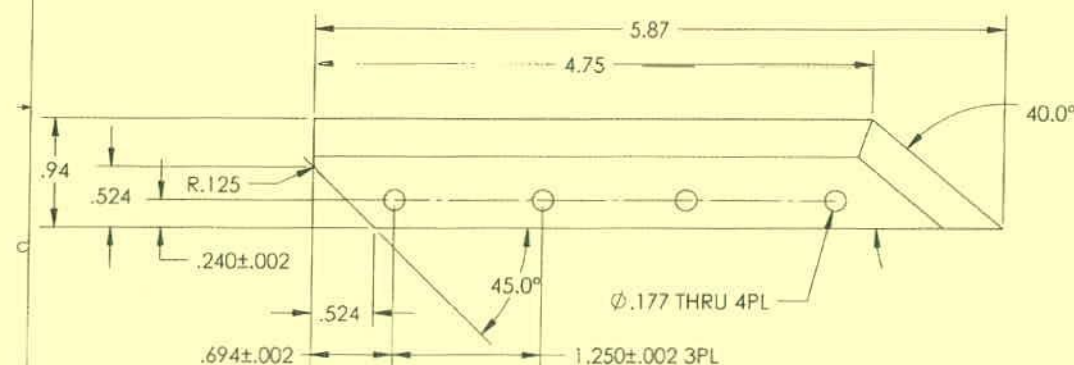
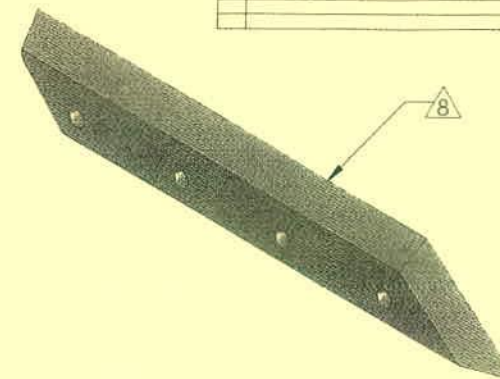


646.3315

DESIGNED (DATE) DRAWN (DATE) CHECKED (DATE) APPROVED (DATE) CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
SHEET OVERPAGE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACES DECIMALS ±.005 UNLESS OTHERWISE SPECIFIED	SCALE: NONE SHEET 7 OF 8

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REVISION			
REV.	DESCRIPTION	DATE	APPROVED



646.3316

ORIGINAL DATE 10/10/1978 DRAWN BY S. HUNT CHECKED BY P. MAYO DRAWING APPROVAL P. MAYO 10/10/1978			
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
UPPER CUTTER ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMAL .001 2 PLACE DECIMAL .005 ANGLES .5°	DWG CODE B 07M76	DWS NO 646.3300	REV N/C
SCALE NONE		SHEET 8 OF 8	